

Work Order ID 83837

Thursday, April 26, 2012 1:08:33 PM

83837

Page 1

Item ID: D4463-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Back
 Start Date: 4/26/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/3/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: UMF Date: 20426 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4463 | C | | | | | (4) | | | |

100 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet Cut as per dwg
 6061.063 Prog rev: C
 Dwg rev: C

110 0.00
110
 QC Memo 0.00
 Quality Control

120 0.00
120
 QC Memo 0.00
 Quality Control

12-51

12-51

(24)

S. Z. S. S.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tank Back

Start Date: 4/26/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 5/3/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

QC6- Inspect dimensions to drawing

0.00

140

QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

SD
12/04/02

(40) 0

(4) 2/12 12-5-3

| W/O: | | WORK ORDER CHANGES | | | | | |
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 *160* QC Quality Control | QC7-Inspect Chemical Conversion Coat Memo | 0.00 0.00 | | | | 4 | 0 | | 12.05.02 |
| 170 *170* Packaging Packaging | Identify as per dwg & Stock Location: <u>W114</u> Memo | 0.00 0.00 | | | | 4 | 0 | | 12.05.02 |
| 180 *180* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | 12/5/3 | 12-05-3 |

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 26, 2012 1:08:33 PM

Page 1

Work Order ID: 83837

Parent Item: D4463-9

Parent Item Name: Tank Back

Start Date: 4/26/2012

Required Date: 5/3/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.11.22 NEW ISSUE DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6S.063 6061-T6 .063 Sheet | | Purchased | No | | | 100 | sf | 286.8422 | 6.614 | 27.848421 | | | |

R12-5-1

Location

Loc Qty

Loc Code

MAT021

286.8422000

113608

0

116308

6.01556842

117285

67.544

119331

44.2

119802

20.94

120218

21

120866

127.142632

121578

121578

4

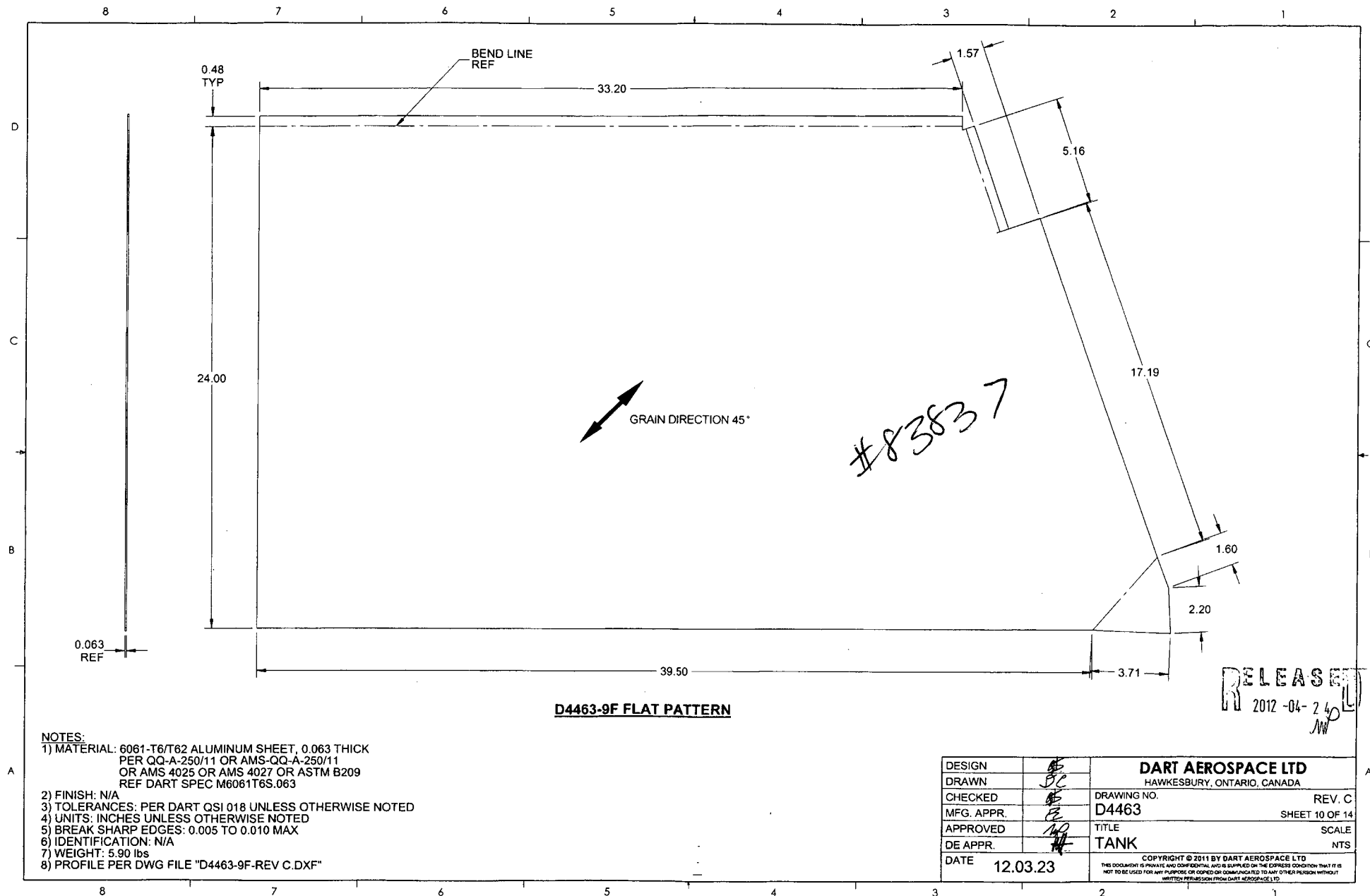
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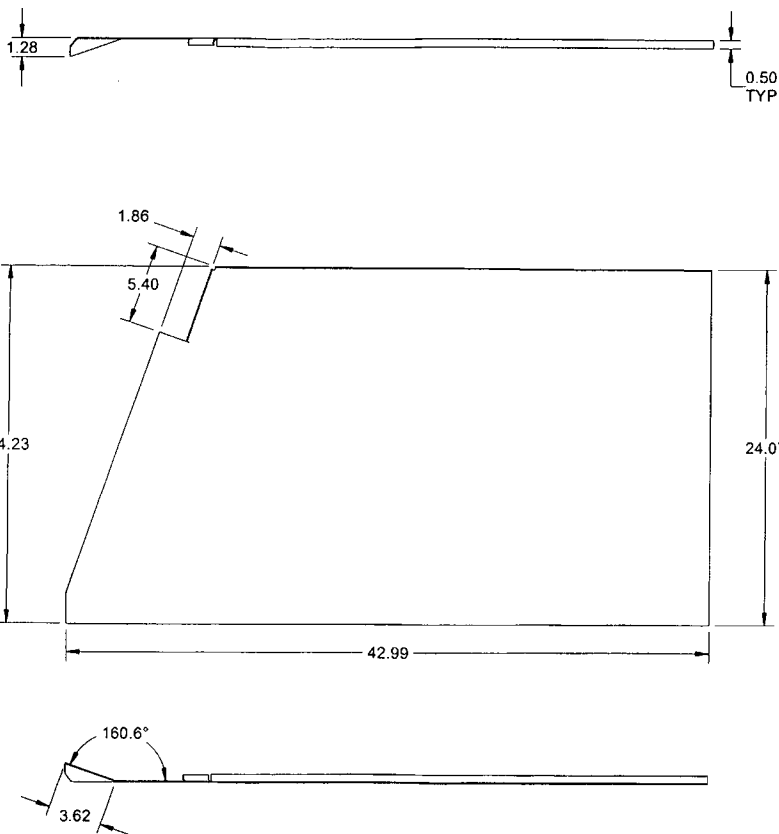
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NOTE: Date & initial all entries



#83837

RELEASED
2012-04-24

D4463-9 TANK BACK

- NOTES:
- 1) MATERIAL: MADE FROM D4463-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 5.90 lbs

| | | | |
|--|----------|--|---------------|
| DESIGN | JB | DART AEROSPACE LTD | |
| DRAWN | JB | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JB | DRAWING NO. | REV. C |
| MFG. APPR. | JB | D4463 | SHEET 9 OF 14 |
| APPROVED | JB | TITLE | SCALE |
| DE APPR. | JB | TANK | NTS |
| DATE | 12.03.23 | COPYRIGHT © 2011 BY DART AEROSPACE LTD | |
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